

to be bored, and it involves more or less work to get the jig in order. The jig in Fig. 10 does not need to be as heavy as would be inferred from the illustration, because a large portion of the bottom can be cored out.

Four-part Boring Jig. —The boring jig illustrated in Fig. 11 consists of four parts; the upright members *A*, *B*, and *C*, and the baseplate *D*, which latter may be used for all jigs of similar construction. This type of boring jig is used only for very large work. In the case illustrated, large lathe heads are to be bored. The work is located on the baseplate between the two members *A* and *C*. The member *B* is only used when the distance be-

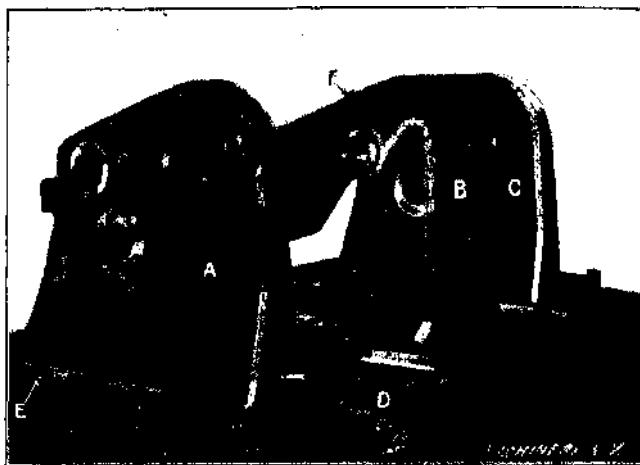


Fig. 11. Boring Jig consisting of Baseplate and Separate Removable Uprights carrying th© Guide Bushings

tween *A* and *C* is very long, so that an auxiliary support for the boring-bar is required, or when some obstacle prevents the bar from passing through the work from one of the outside members to the other. As a rule these members are located on the baseplate by a tongue fitting into one of the slots as shown at *E*. The members are brought as close as possible to the work, sufficient space, of course, being permitted for the cutting tools to be inserted. The standards are cored out and ribbed and lugs provided so as to give the bearing bushings long and substantial support. Good results will be obtained